

SPUT

Dart Aerospace Ltd.

Date: Wednesday, 7/4/2007 10:17:31 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 33284	Part Number	: D35371
Estimate Number	: 12712	Drawing Number	: D3537 REV C
P.O. Number	: <u>N/A</u>	Project Number	: N/A
This Issue	: 7/4/2007 S.O. No. : <u>N/A</u>	Drawing Revision	: C
Prsht Rev.	: NC	Material	: <u>N/A</u>
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Due Date	: 7/22/2007
Previous Run	: 33227	Qty:	40
Written By	: <u>[Signature]</u>	Unit:	Each
Checked & Approved By	: <u>07.07.04</u>		
Comment	: Est Rev:A New Issue 07-02-14 JLM		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0788 sf(s)/Unit Total: 3.1500 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: M 7106 12 07-07-06

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

12 07-07-06

PIC

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

12 07-07-06

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SN 07/07/10

(x40)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

SB 07/07/10

Date: Wednesday, 7/4/2007 10:17:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33284

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

M 104463

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

07/07/11 13

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/11 (12)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/11 (12)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR/FL 07-07-11

(12)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/07/11

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

07-07-11

(12)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/11

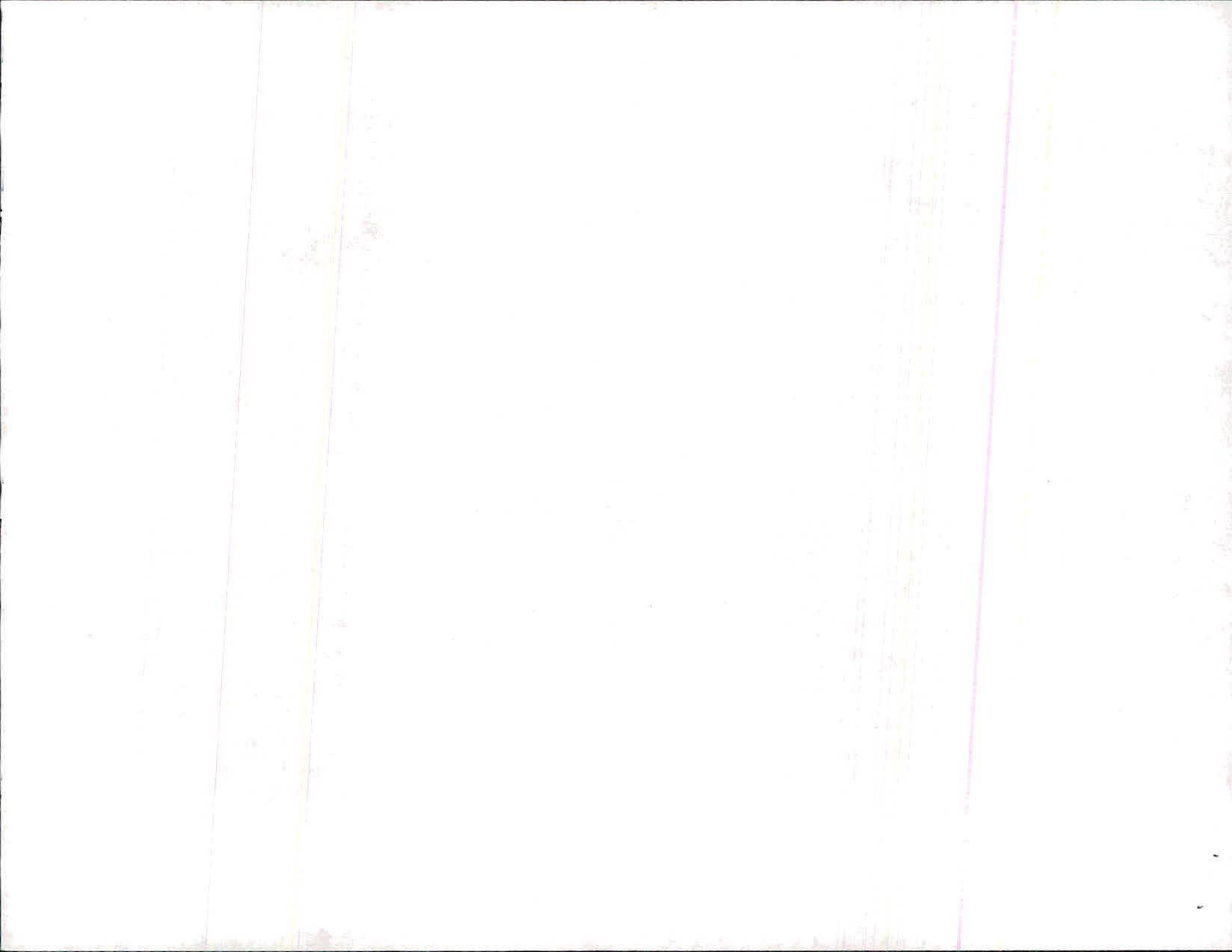
(12)

Job Completion

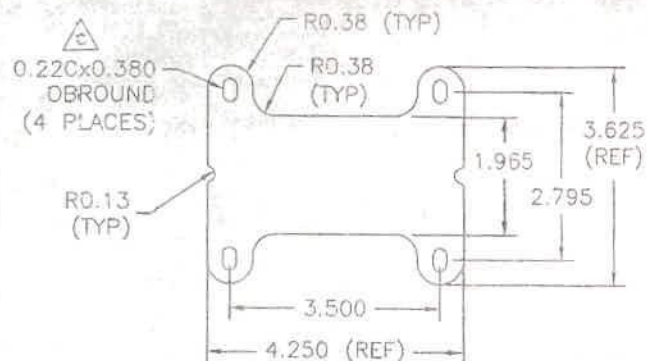


07/07/12

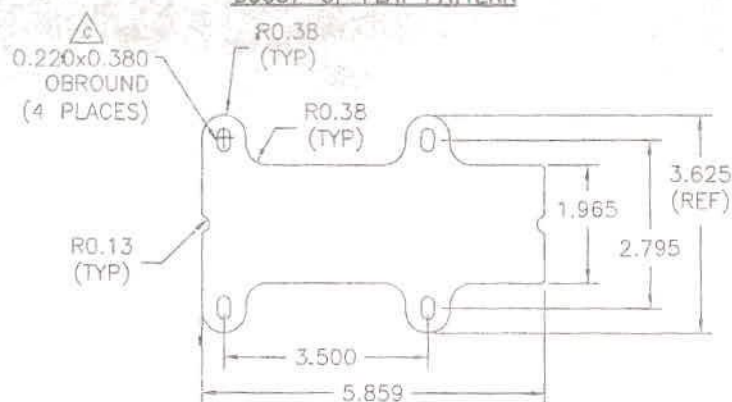




D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

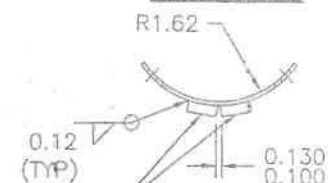


SECTION A-A



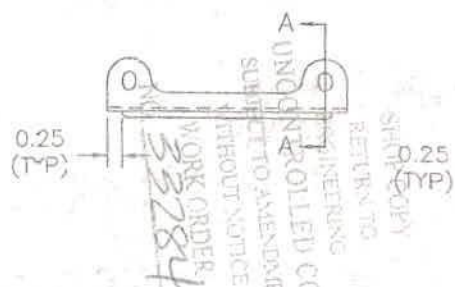
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B

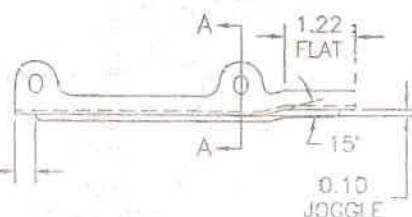


D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

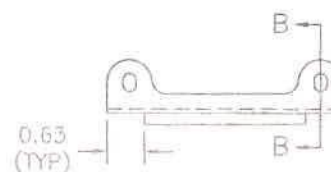
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



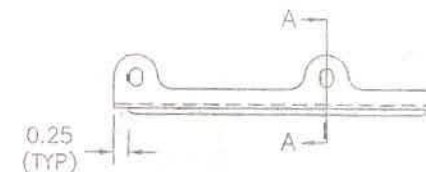
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN.
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	✓	APPROVED
DATE	07.04.13	DRAWING NO. D3537
		WEARPAD

DART DART AEROSPACE USA, INC.
PORT HADLOCK, OH

REV. C
SHEET 1 OF 1

1-2

RELEASED
07.05.08 Ad
PER ECU
96A

